

Work Order ID 54468

December 09, 2009 1:40:18 PM



Page 1

Item ID: D2917-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH

Stop



Start Date: 12/10/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 12/28/2009 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: *mmf* Date: *09-12-09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2917	Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number Machine Step No 1 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet Machine Step No 2 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet Machine Step No 3 as per Folio

8

0.00

110



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

8

0.00

120



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

8

DTP
10/01/05 *mmf*
10/01/04

DTP
10/01/05 *mmf*
10/01/04

DTP
10/01/05 *mmf*
10/01/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54468

December 09, 2009 1:40:18 PM



Page 2

Item ID: D2917-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH

Stop



Start Date: 12/10/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 12/28/2009 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				8			
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 11113170 Memo START TIME: 8:50am 9:20am FINISH TIME: 3:20pm	0.00 0.00				18			

BR 10-01-05

BR 10-01-06

BR 10-01-06

8

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54468

December 09, 2009 1:40:18 PM

Page 3

Item ID: D2917-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle LH

Start Date: 12/10/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 12/28/2009 Req'd Qty: 8.00

Customer:




Reference:

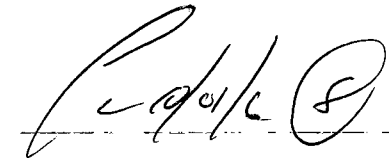
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____


Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BR 10-01-6			8			
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							



10/01/09 
PL 10-1-04
8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 09, 2009 1:40:17 PM

Page 1

Work Order ID: 54468



Parent Item: D2917-1



Parent Item Name: Saddle LH


Start Date: 12/10/2009

Required Date: 12/28/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010  Saddle Billet		Manufactured	No			100	Each	11.0000	8.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

11

51423

1

53519

10

8

MMF 10/01/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

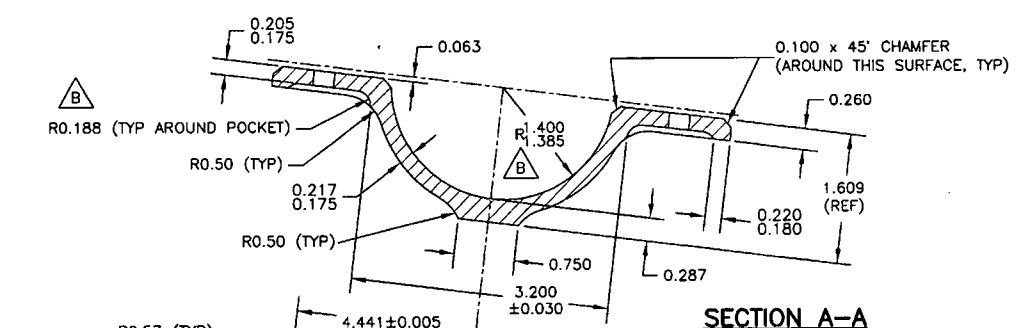
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

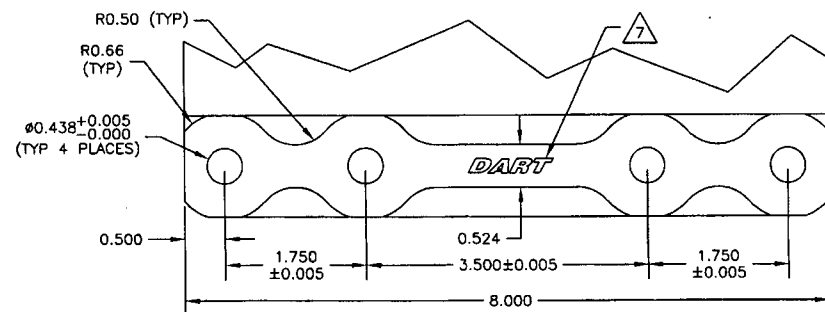
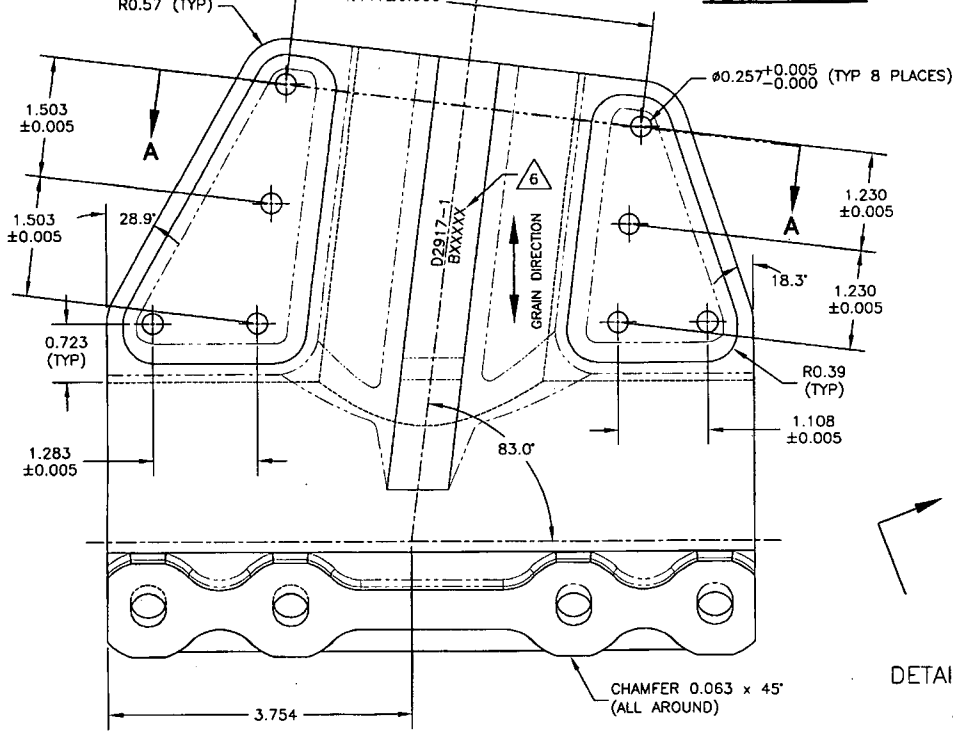
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#54468



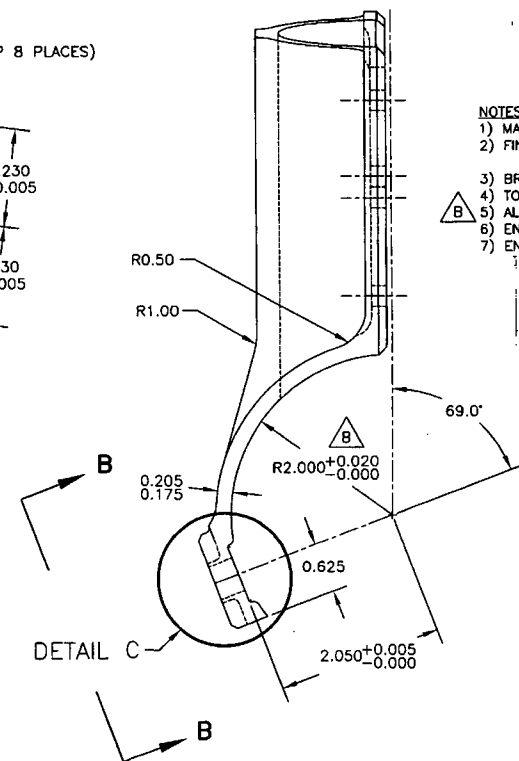
SECTION A-A



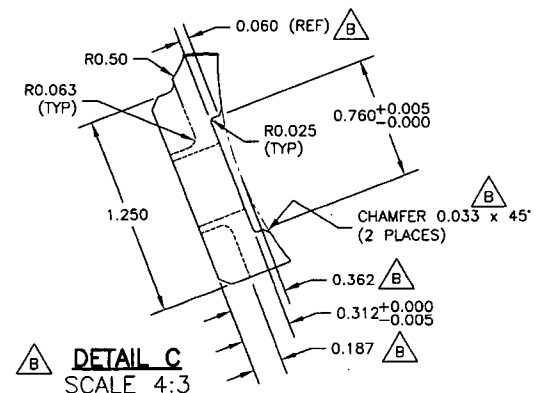
VIEW B-B

D2917-1 LH SADDLE (SHOWN)
D2917-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART OSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 - 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



DETAIL C



DETAIL C
 SCALE 4:3

RELEASED

c7.07.31

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

B	07.06.26	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	GP	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	07.06.26	TITLE SADDLE
DART	DART AEROSPACE LTD.	MARKESBURY, ONTARIO, CANADA
DRAWING NO.	D2917	REV. B
SHEET 1 OF 1		SCALE
		2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries